

Date: Monday, 12/11/2006 12:54:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 29851		
Estimate Number	: 10349		
P.O. Number	: <i>N/A</i>	Part Number	: D28582
This Issue	: 12/11/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2858 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28284	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	24 Um: Each
Comment	: Est C 0006.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)
 Material: 1.50" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B15001250
 Batch *M-101694*

mk 06/12/23 27

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

mk 06/12/23 27

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2858-2

Sp 06/12/24 27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Sp 06/12/24 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 07/10/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/11/2006 12:54:12 PM
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Drawing Name: HINGE BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 06/12/24

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

06/12/24 x27

2-Deburr any rough edges after tumbling

06/12/28 x27

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 06/12/29

27

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

M/M-Q

07/01/02

(27)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M 102391

SL/a.m

07/01/05

(27)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL 7/01/08

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SL 393

SL 07/01/08 (27) SL 7/01/08

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SL 07/01/08

Job Completion



SL 07.01.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29851
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	0.173	/			
Ø0.400	+0.005/-0.000	0.400	/			
R0.125	+/-0.010	0.125	/			
0.328	+/-0.010	0.324	/			
0.820	+/-0.005	0.818	/			
1.476	+/-0.010	1.478	/			
0.342	+/-0.010	0.337	/			
0.875	+/-0.010	0.872	/			
1.56	+/-0.030	1.565	/			
0.147	+/-0.010	0.146	/			
0.717	+/-0.010	0.710	/			
0.697	+/-0.010	0.698	/			
0.229	+/-0.010	0.230	/			
R0.125	+/-0.010	0.125	/			
R0.063	+/-0.010	0.063	/			
0.063	+/-0.010	0.064	/			
0.126	+/-0.010	0.133	/			
0.630	+/-0.010	0.635	/			
R0.354	+/-0.010	0.350	/			
0.965	+/-0.010	0.967	/			
Ø0.166	+0.005/-0.000	0.168	/			

Measured by: E	Audited by: M	Prototype Approval:	N/A
Date: 06/12/23	Date: 06/12/23	Date:	N/A

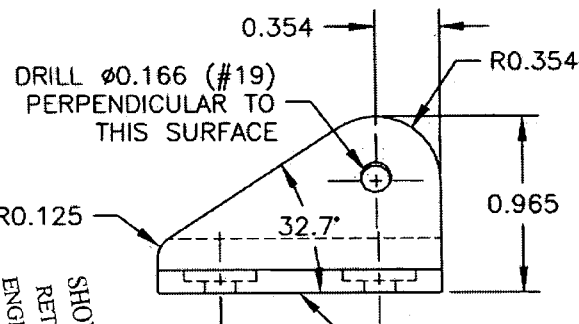
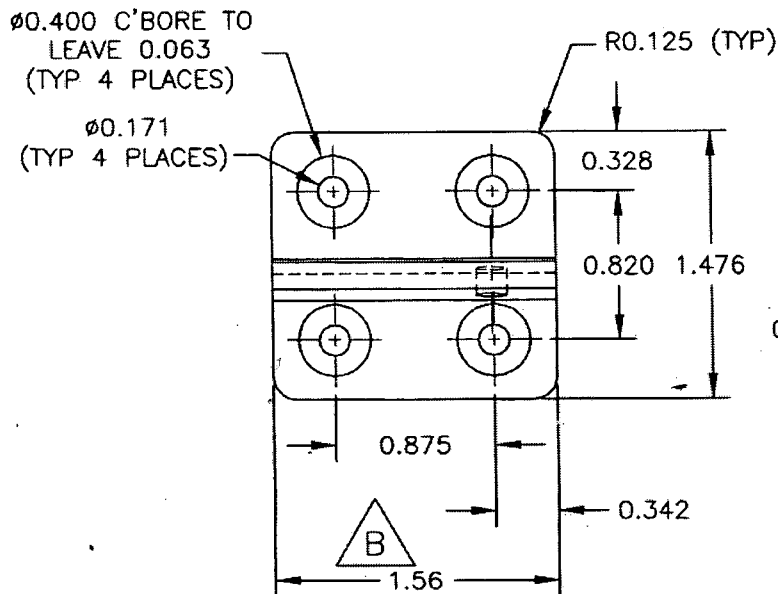
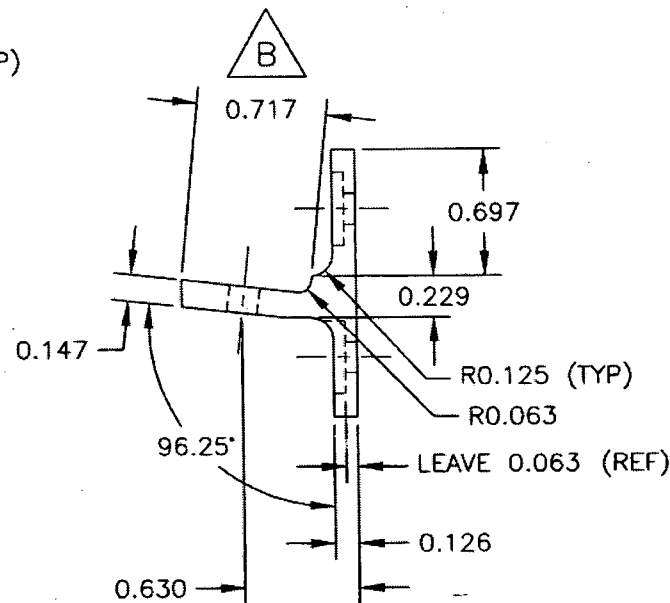
Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	

DART



RELEASED
99.07.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
VE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
UP	#	D2858
DATE	TITLE	REV. B
99.02.28	HINGE BRACKET	SHEET 1 OF 1
A	NEW ISSUE	SCALE
B	99.02.28	1:1



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED